



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE2-10-1
Job Sheet 186981



Part No: RBE2-10-1

Job Qty: 6 pcs

Part Name: Fuel System Cartridge Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/23/18

Job Tracking No:

Due Date: 1/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBE2-10-1 Rev A IPP Rev A 18.01.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	6 pcs	1/11/19		0.00	2.00	Small Fab - 1		
							Small Fab - 2		MCC
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	6 pcs	1/11/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
130	Packaging 3-1 - Stock - B4B	6 pcs	1/11/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S153493

Part: RBE2-10-1

Job No: 186981

Serial No/Batch: S153493

Revision: A

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/14/19

DAS
58 FEB 14 2019
9-89

DAS
28
9-89

				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	6 pcs	1/11/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70

Part Op 100 - Small Fab -Assemble as per DWG sheet 1
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 130 - Identify as per dwg & Stock Location: _____
 140 - Identify as per dwg & Stock Location: _____

DAG
21
8-25
FEB 14 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
91257A481	Hex Head Screw 7/16"-20 x 6" LG.	6 Ea (1 ea)	100-Small Fab - 1	5137371
93839A820	Thin Hex Nut 7/16"-20	12 Ea (2 ea)	100-Small Fab - 1	5137372
RBE2-10-1-01	Slide	6 pcs (1 ea)	100-Small Fab - 1	5119221

69
56
141C

1 stock 41 5119221
RBE2-10-1-01 5144624

Job Allocations			
Component Part	Required	Inventory	Allocated
A481	6	15	0
A820	12	55	0
-10-1-01	6	11	0

Part Specifications	
Specifications could not be found.	



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Type: SOLD

Description:

Note: DWG RBE2-10-1 Rev A IPP Rev A 18.01.12 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	1/11/19	1/11/19	0.00	0.00	Start Up Small Fab-4		
100	Small Fab	6 pcs	1/11/19	1/11/19	0.00	2.00	Small Fab-5		
110	QC	6 pcs	1/11/19	1/11/19	0.00	0.00	QC5		
130	Packaging	6 pcs	1/11/19	1/11/19	0.00	0.00	Packaging3-2		
140	QC21-FG	6 Ea	1/11/19	1/11/19	0.00	0.00	QC21		

Part Op 100 - -Assemble as per DWG sheet 1
Descriptions: 130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91257A481	Hex Head Screw 7/16"-20 x 6" LG.	6 Ea (1 ea)	90-Start up Operation	
93839A820	Thin Hex Nut 7/16"-20	12 Ea (2 ea)	90-Start up Operation	
RBE2-10-1-01	Slide	6 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	91257A481	6	0	0
	93839A820	12	5	0
	RBE2-10-1-01	6	4	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

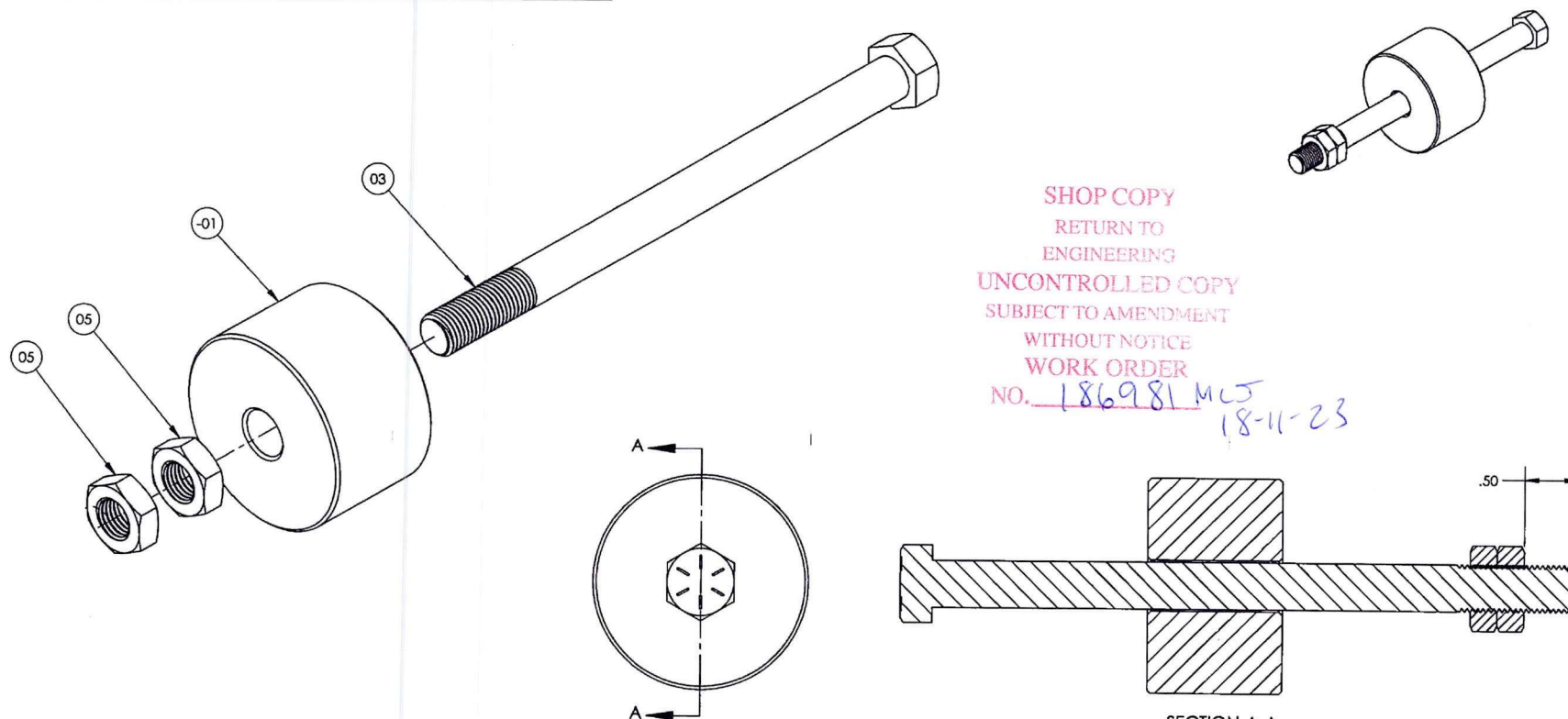
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation			Disposition																		
			Completed By																		
			Lead hand / Supervisor Approval Verification																		
			QC / QA Coordinator Approval																		
<table style="width:100%; border: none;"> <tr> <td style="width:25%; vertical-align: top;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:25%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:25%; vertical-align: top;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:25%; vertical-align: top;"> FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:25%; vertical-align: top;"> Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:25%; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>						Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐										
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OTHER : ☐																					

ITEM #	QTY	PART #	TITLE	PG
-01	1	RBE2-10-1-01	SLIDE	2
03	1	McMaster#91257A481	HEX HEAD SCREW 7/16"-20 x 6" LG.	-
05	2	McMaster#93839A820	THIN HEX NUT 7/16"-20	-

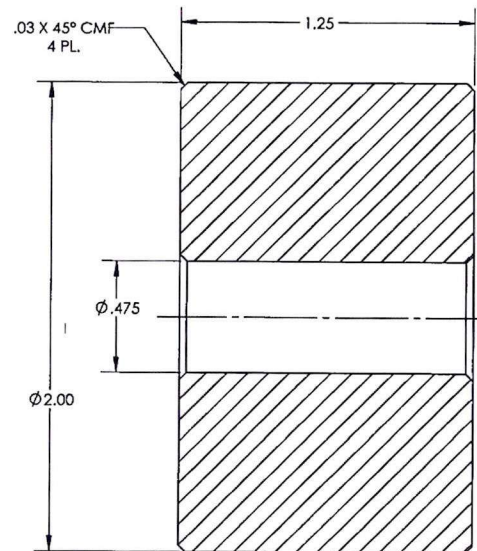
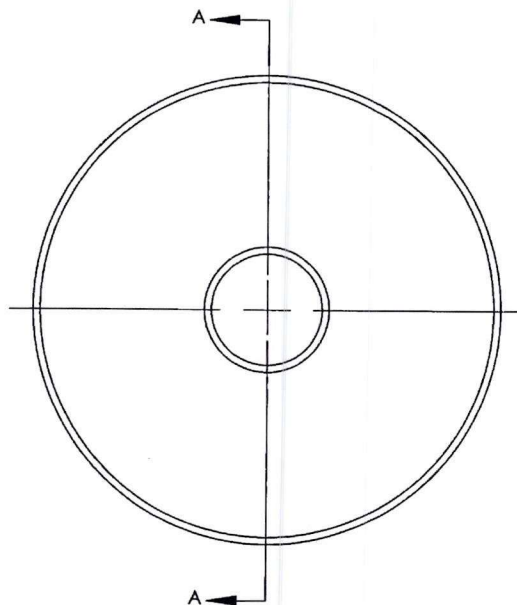
REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
A	NEW ISSUE	17-688	17.10.02	VM	WM



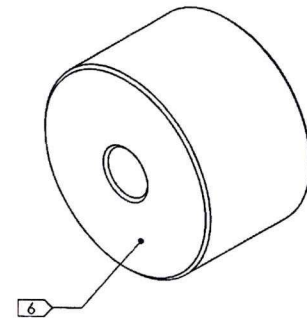
RBE2-10-1 FUEL SYSTEM CARTRIDGE REMOVAL TOOL

- NOTES:**
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) SPEC: N/A
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE FUEL SYSTEM CARTRIDGE REMOVAL TOOL	
DWG NO. RBE2-10-1	REV A
DESIGN BY: VM 10/2/2017	300K ± .005 FRACTIONS ± 1/8
DRAWN BY: VM 10/2/2017	XX ± .01 ANGLES ± .5°
CHECKED BY: SAG 10/2/2017	XX ± .1 SURFACES ± 125
MFG. APPR: DP 10/2/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED BY: WM 10/2/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 10/2/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: N/A
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SHEET 1 OF 2	



SECTION A-A

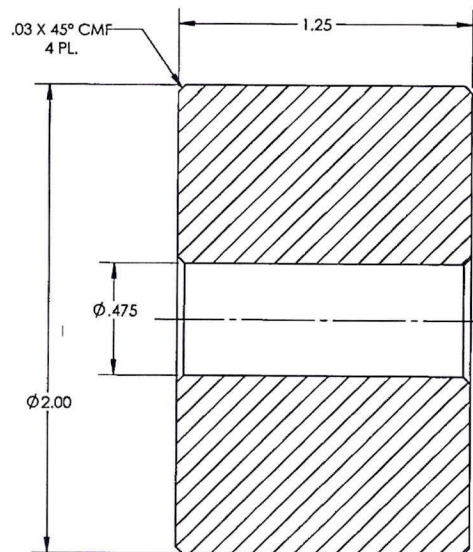
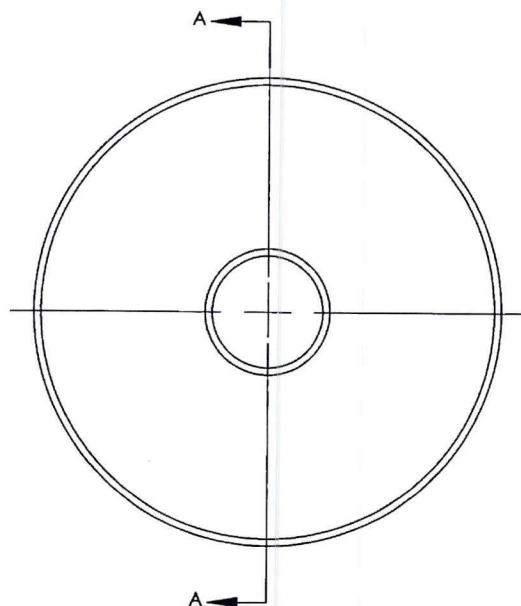


RBE2-10-1-01 SLIDE

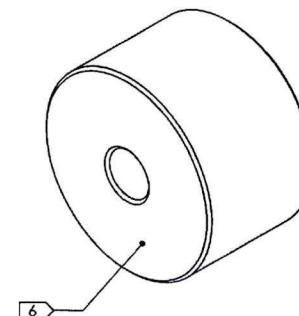
NOTES:

- 1) MATERIAL: AISI 1018/1020 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE
- 4) SPEC: MIL-C-13924, CLASS 1; MIL-C-16173 GRADE 4
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE P/N & S/N

DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE SLIDE			
DWG NO. RBE2-10-1-01		REV A	
DESIGN BY: VM 10/2/2017	XXX ± .003 FRACTIONS & 1/8	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED 2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
DRAWN BY: VM 10/2/2017	XX ± .01 ANGLES 2.5°		
CHECKED BY: SAC 10/2/2017	X ± .1 SURFACES = 125		
INFO. APPR: JDP 10/04/2017			
APPROVED BY: VM 10/04/2017			
DATE: 10/2/2017			
SCALE: NTS	WEIGHT: 1.056 LBS	SHEET 2 OF 2	
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SECTION A-A



RBE2-10-1-01 SLIDE

NOTES:

- 1) MATERIAL: AISI 1018/1020 CR
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE
- 4) SPEC: MIL-C-13924, CLASS 1; MIL-C-16173 GRADE 4
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: MACHINE ENGRAVE P/N & S/N

DART AEROSPACE Hawkesbury, Ontario, Canada	
TITLE SLIDE	
DWG NO. RBE2-10-1-01 REV A	
DESIGN BY: VM 10/2/2017	XXX ± .005 FRACTIONS & 1/8
DRAWN BY: VM 10/2/2017	XX ± .01 ANGLES & 15°
CHECKED BY: SAC 10/2/2017	X ± .1 SURFACES = 125
MFG. APPR: WDP 10/04/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED
APPROVED: WWM 10/04/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE: 10/2/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING
SCALE: NTS	WEIGHT: 1.056 LBS
COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	